

Work Order ID 73529

Thursday, September 01, 2011 2:55:32 PM

Page 1

Item ID: D2873-045

Accept

Setup Start

Revision ID:

Stop

Item Name: Nut Plate Assembly

Start Date: 9/1/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2873

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 2.700" long

ark 11/09/08

20

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873: Identify as D2873-5
Dwg Rev A F1819Folio Rev AA

ark/B.A 11/09/08

20

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ark/B.A 11/09/08

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Deburr 1-2- C'sink as per Dwg D2873

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control



JK 11-09-12

20

9/5/09/12

20

9/10/12

100%
20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

20xØ M-11/09/12

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20 BR 11-9-12.

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D2873 2-Identify as D2873-045

11/09/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: X-tube

0.00



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Subtotal

counts
720

11 *09* *13* *(20)*

11/9/14

ME
11-09-B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, September 01, 2011 2:55:29 PM

Page 1

Work Order ID: 73529

Parent Item: D2873-045

Parent Item Name: Nut Plate Assembly



Start Date: 9/1/2011

Required Date: 9/9/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.09.13 New issue: KJ/JLM:1

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.00 0		Purchased	No			180	f	36.0000	0.225	4.736842			



6061T6 BAR .375 x 1.00



Location	Loc Qty	Loc Code
MAT	36	
113325	0	
118641	36	

MS20426AD4-6 Purchased No

180 Each 949.0000 4 80



Rivet



Location	Loc Qty	Loc Code
GA	354	
118510	354	
ST317	595	
110139	201	
117505	394	

MS21075L5 Purchased No

100 Each 126.0000 2 40



Nut Plate



Location	Loc Qty	Loc Code
ST303	126	
116914	1	
118542	125	

4.74 on 11/09/08

EP 11/09/12

80

EP 11/09/12

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 73529
Description: Radius Block		Part Number: D2873-5
Inspection Dwg: D2873	Rev: A	Page 1 of 1

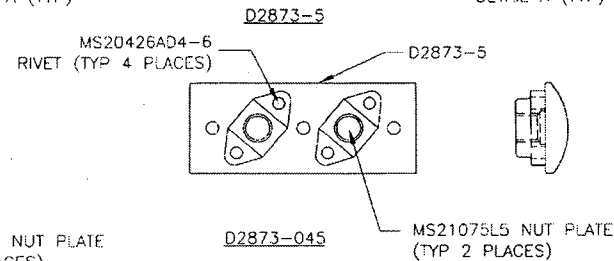
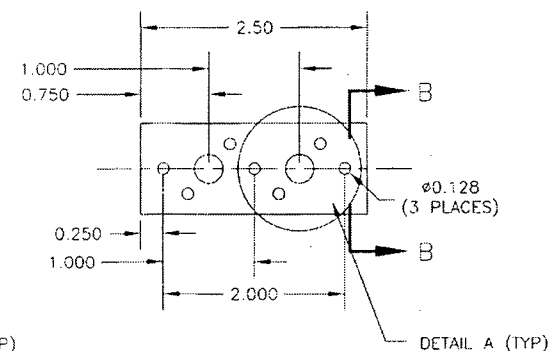
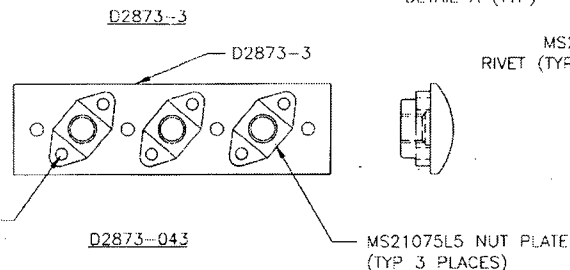
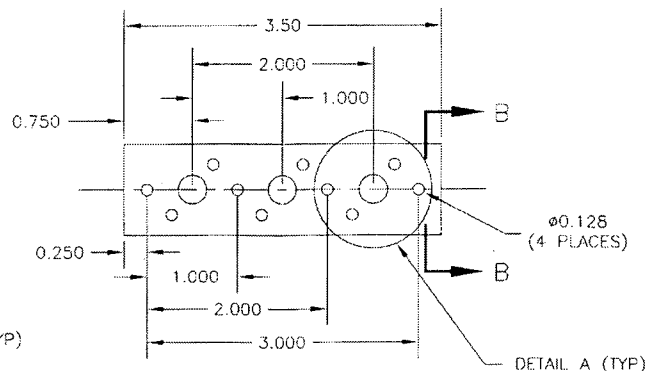
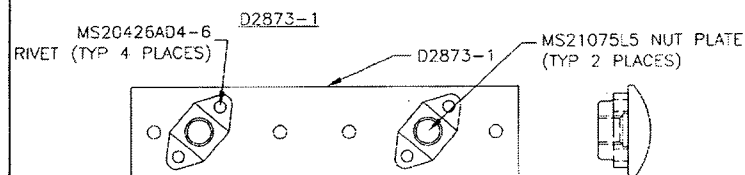
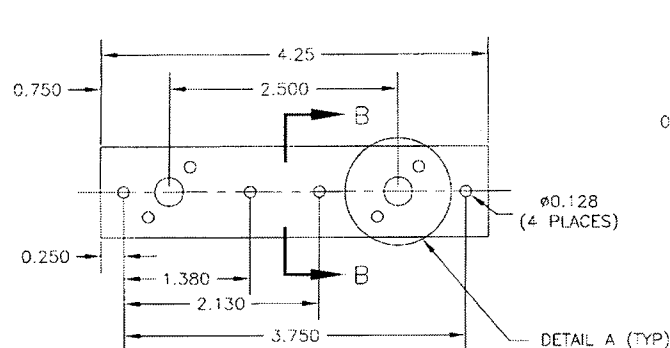
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.500	/			
1.000	+/-0.010	1.000	/			
0.750	+/-0.010	.750	/			
0.250	+/-0.010	.250	/			
1.000	+/-0.010	1.000	/			
2.000	+/-0.010	2.000	/			
Ø0.128	+0.005/-0.001	Ø.130	/			
0.359	+/-0.010	0.359	/			
Ø0.316	+0.006/-0.001	Ø.317	/			
1.000	+/-0.010	1.000	/			
0.250	+/-0.010	.252	/			
0.061	+/-0.010	.060	/			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø.230 x .125	/			

Measured by: B. A. B. L.	Audited by: J. L.	Prototype Approval:	N/A
Date: 11/09/08	Date: 11-09-12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM	[Signature]



D2873-1/-3/-5 RADIUS BLOCK

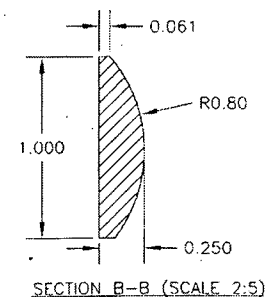
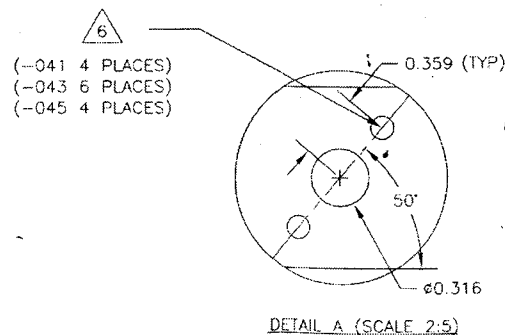
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) $\varnothing 0.128$ PILOT + C'BORE CURVED SIDE $\varnothing 0.230 \times 0.125$ DEEP + C'SINK CURVED SIDE $\varnothing 0.225 \times 100^\circ$

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.26	TITLE
		RADIUS BLOCK
		SCALE
		4:5